

Split

Work Order ID 71422-1

Monday, July 04, 2011 10:46:27 AM



Page 1

Item ID: D4153-1

Accept



Setup Start



Revision ID:

Item Name: Joggle Bracket

Stop



Start Date: 7/5/2011 Start Qty: 4.00



Required Date: 7/19/2011 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *MP*

Date: *11-07-04* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description



Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4153

A U/R

Rev A

Rev A

11.07.05

MAKE PER

Rev A

110

0.00



Waterjet

0.00

FLOW CNC Waterjet

304 .050

Memo

CUT AS DWG

DWG REV: *081*

PROG REV: *081*

DEBURR

B11-7-5

(6)

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

Quality Control

0.00

B11-7-5

rework

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ID 71422

04, 2011 10:46:27 AM



Page 2

ID: D4153-1

Revision ID:

Item Name: Joggle Bracket

Start Date: 7/5/2011 Start Qty: 4.00

Required Date: 7/19/2011 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*- inspector to
PBI Dry only**Sublog**(ste)*

140



Brake NC

Brake NC

Form as per dwg

Memo

0.00

0.00

*SB 11/07/11
SB 11/09/06**2**(2)*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*- inspector to PBI
Dry only
Sublog**(x6)**- inspector to**hand change of
Rev A Dry**Sublog**(+2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ID 71422

10/04, 2011 10:46:27 AM



Page 3

ID: D4153-1

Revision ID:

Item Name: Joggle Bracket

Start Date: 7/5/2011 Start Qty: 4.00

Required Date: 7/19/2011 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11-09-06

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/17

ME
11-09-07

POSITIVE RECALL

EFFECTIVE 11.07.05 AUTH CP

RELEASED DATE 11.09.07

PER ATTACHED EMAIL
FROM D. SHEPHERD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2011 10:46:25 AM

Item ID: 71422

Parent Item: D4153-1

Parent Item Name: Joggle Bracket



Page 1

Comments: IPP Rev:A 10.10.06 new issue DD ver:EC

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location
---------------------------------	------------------------	---------------	-------------	---------------------	------------------

M304S18GA



304/316 .050 Sheet

Purchased

No

Location

MAT020

113062

116979

117653

Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

110

sf

104.6550

0.875

3.684211

5.5



1311-7-5

Loc Qty

104.655

13.655

69

22

Loc Code

117653

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

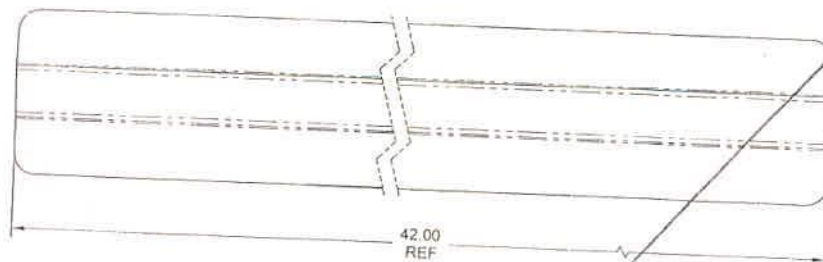
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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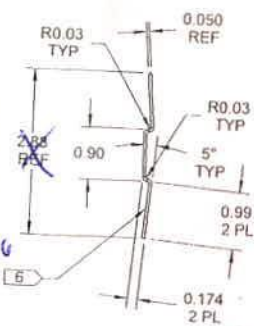
FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ 	

71422



2.94
2.90
REF
0.050



D4153-1 JOGGLE BRACKET
(MAKE FROM D4153-1F FLAT PATTERN)

UNDER REVIEW
10/11/09

RELEASED
2010-09-23

- NOTES
- 1) MATERIAL: MAKE FROM D4153-1F FLAT PATTERN
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1, ON THE UNDERSIDE OF THE PART AS INDICATED
 - 7) WEIGHT: 1.82 lbs

A NEW ISSUE		DESCRIPTION		RF	10.09.10
REV.				BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA			REV. A
DRAWN	RF				
CHECKED	<i>10</i>	DRAWING NO.			SHEET 1 OF 2
MFG. APPR.	<i>15</i>	D4153			
APPROVED	<i>10</i>	TITLE			SCALE
DE APPR.	<i>11</i>	JOGGLE BRACKET			
DATE	10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

R0.38
TYP

0.00

BEND LINE

3.00
2.00
1.91
1.09
1.00
0.00

42.00

0.050
REF

D4153-1F FLAT PATTERN

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 18 GAUGE (0.050 THICK)
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC M304S18GA

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.82 lbs

UNDER REVIEW

10/10/10

RELEASED
2010-09-23
U

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. A
MFG. APPR.	10	D4153	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	10	JOGGLE BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order:	71422
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DART AEROSPACE LTD

Description: Jigsaw Bracket.

Part Number: ① 21153-1 (Bent)

Inspection Dwg: 2153 Rev: PB1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

[illegible]

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

Date:

N/A

N/A

Rev

Date _____

Change

New Issue

Revised by
KJ/JLM

Approved

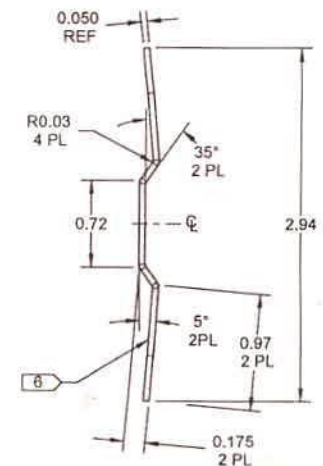
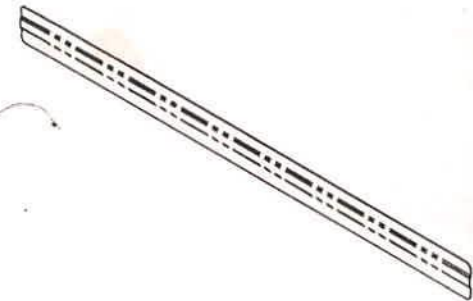
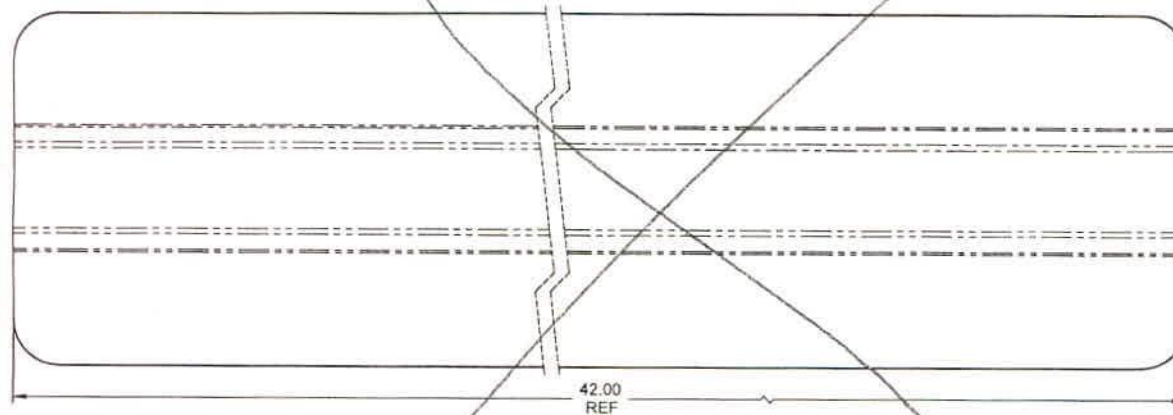
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NOTE: Date & initial all entries



D4153-1 JOGGLE BRACKET
(MAKE FROM D4153-1F FLAT PATTERN)



PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: MAKE FROM D4153-1F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1, ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WEIGHT: 1.81 lbs

PB1	RE-DESIGN	RF	10.10.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4153	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		JOGGLE BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

R0.38
TYP

0.00

BEND LINE

3.00
2.04
1.85
1.15
0.96
0.00

42.00

0.050
REF

D4153-1F FLAT PATTERN

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 18 GAUGE (0.050 THICK)
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4153	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		JOGGLE BRACKET	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: David Shepherd <dshepherd@dartaero.com>
Sent: July 20, 2011 11:11 AM
To: 'Linda Lacelle'; 'Robert Fuentes'
Cc: 'Mike Petsche'
Subject: RE: D4153-1

Linda,

As discussed, we are going to be sending out an UNDER REVIEW form that clarifies what to do with some of the AW139 parts. D4153-1 Rev A are acceptable to ship, but there is a change coming.

David

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: July-20-11 5:22 AM
To: Robert Fuentes
Cc: dshepherd@dartaero.com; 'Mike Petsche'
Subject: D4153-1
Importance: High

Is still in Prelim, but all the 139's are released...??? Need to ship next week..

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1655

Kim Johnston

From: David Shepherd <dshepherd@dartaero.com>
Sent: Friday, July 22, 2011 1:00 PM
To: 'Linda Lacelle'; 'Roberto Fuentes'
Cc: Mike Petsche; 'Kim Johnston'
Subject: RE: Under Review - D4092, D4093, D4153, D4074 and D4131

Linda,

As discussed:

- a) D4092/D4093 should not be manufactured as is
- b) There are changes coming on D4153 and D4131, but it is acceptable to manufacture and release parts that are made per per D4153 Rev A and D4131 Rev A
- c) All D4074-X parts must be manufactured per D4074 Rev B ... There is no change to D4074-1/-5 but changes are required to D4074-3/-7. D4074 Rev B should arrive in Hawkesbury today.

Hope this clarifies the situation ... Sorry for any confusion.

David

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: July-22-11 7:16 AM
To: 'Roberto Fuentes'
Cc: dshepherd@dartaero.com
Subject: RE: Under Review - D4092, D4093, D4153, D4074 and D4131

I have kits to ship next week, and more the week after, when is 4074, 4153 and 4131 all going to be released??

L

From: Roberto Fuentes [mailto:rfuentes@dartaero.com]
Sent: July 20, 2011 11:45 AM
To: Linda Lacelle
Cc: 'Stocker, Alan'; 'Beckett, Bill'; 'Golden, Brigitte'; 'Lavoie, Chantal'; 'Provencal, Chris'; 'Campbell, Daniel'; 'Duval, David'; 'Shepherd, David'; 'Charbonneau, Eric'; 'Downing, Eric'; 'Siemens, Harvey'; 'Jean-Francois Sauve'; 'Menard, Jean-Luc'; 'Johnston, Kim'; 'Fauteux, Melanie'; 'Petsche, Mike'; 'Willems, Sian'; 'Bedford, Sue'; 'Sheldon, Susanne'; 'Kerr, Cathy'; Marc Bellavance
Subject: Under Review - D4092, D4093, D4153, D4074 and D4131

Hi everyone,

D4092, D4093, D4453, D4074 and D4131 drawings are now under review per attached form.

Thanks,
Roberto